

Monday, 4/23/2007 1:52:52 PM
User: Kim Johnston

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 31998 - 1		
Estimate Number	: 12712		
P.O. Number	: N/A	Part Number	: D35371
This Issue	: 4/23/2007 ✓ S.O. No. : N/A	Drawing Number	: D3537 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B PH 07.04.26
Previous Run	: 31937	Material	: N/A
Written By	:	Due Date	: 4/30/2007 Qty: 100 Um: Each
Checked & Approved By	: <u>JLM 07.04.26</u>		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s) M304S16GA .063" 304 SS SHEET Batch: <u>M101873 X</u> ml 07.04.26 105		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <u>B</u> ml 07.04.27 105 Prog Rev: <u>B</u> 105		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1 		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			07/05/04					

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:52 PM
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Drawing Name: WEARPAD

Job Number: 31998

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat 102755

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

FC 07/05/04

(40)

7.0 QC9



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/04

(40)

8.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/04

(40)

9.0 POWDER COATING



POWDER COATING



M 101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

esl

07/05/04

(40)

10.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



(40X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-f 07/05/04

(40X)

11.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP18

m-f 07/05/04

(40)

12.0 QC21



FINAL INSPECTION/W/O RELEASE



07/05/04

(40)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07/05/04

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31998
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: A B PH 01-0426	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

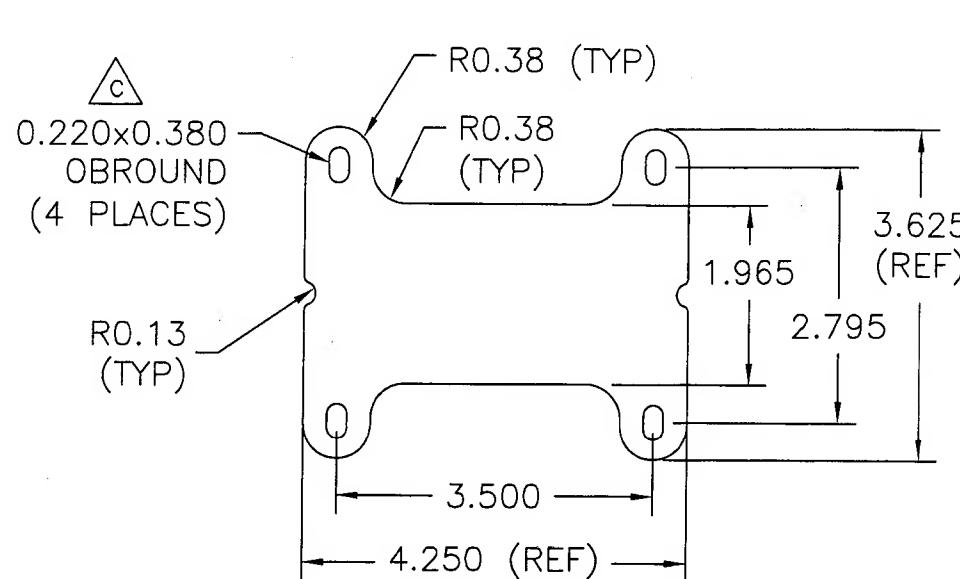
X First Article

PA
07-0436

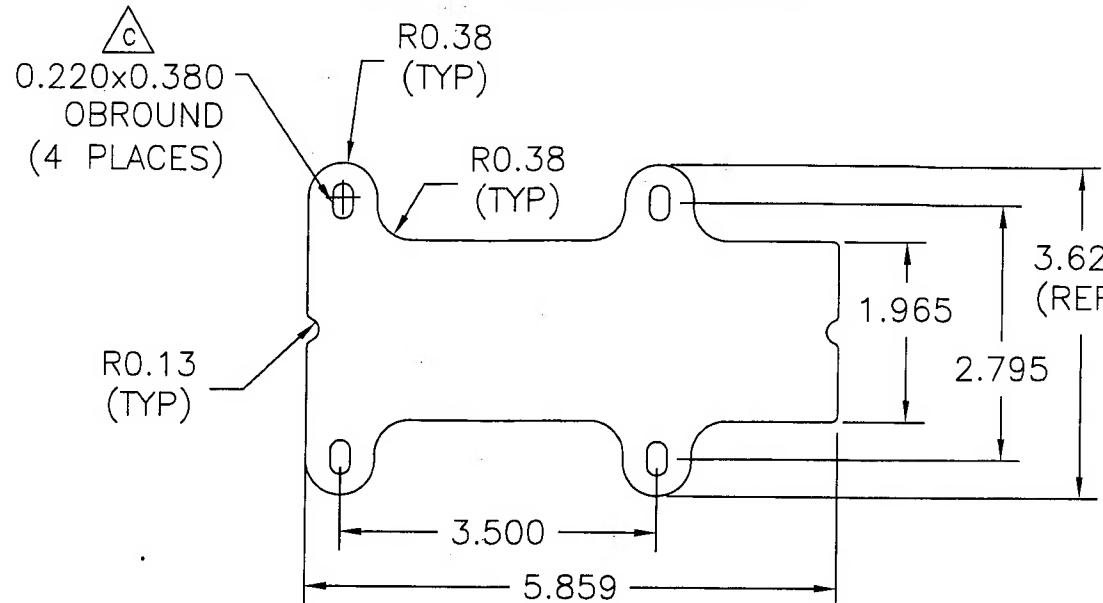
Measured by:	<i>M. M</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	07/04/28	Date:	07/04/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

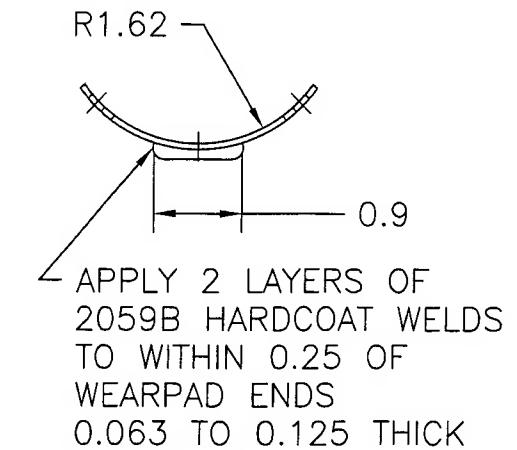
D3537-1F FLAT PATTERN



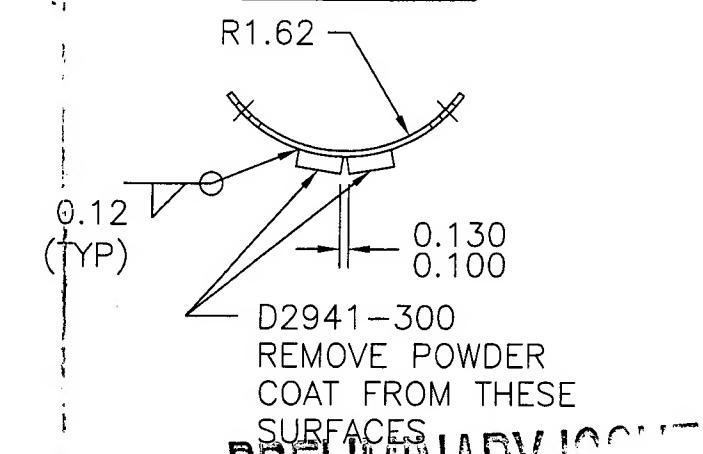
D3537-3F FLAT PATTERN



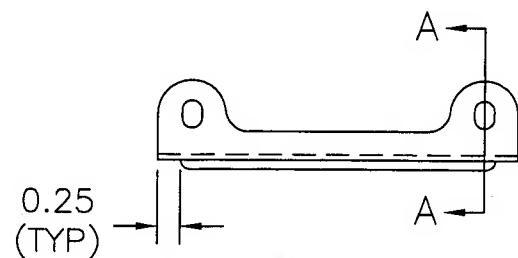
SECTION A-A



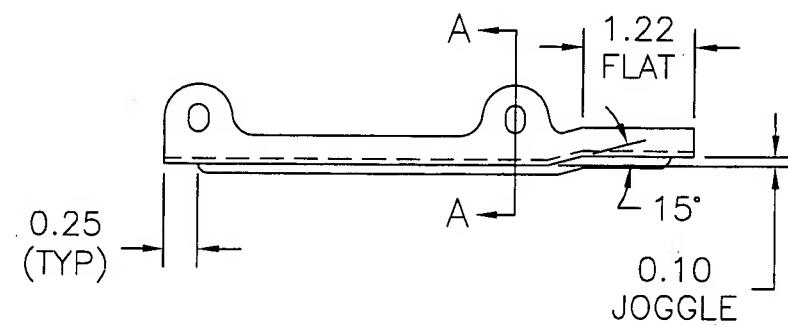
SECTION B-B



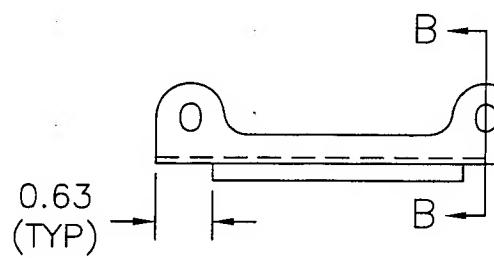
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



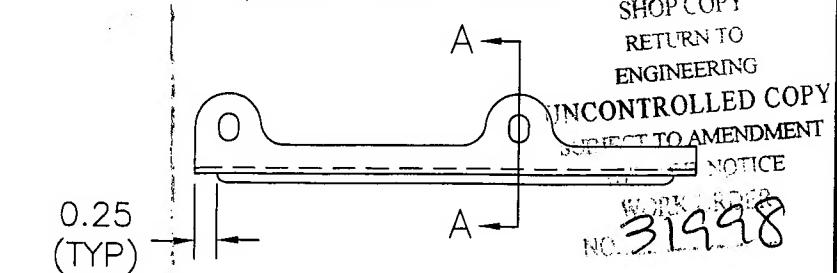
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
CHECKED	APPROVED	DRAWING NO. D3537
DATE		REV. C SHEET 1 OF 1 TITLE WEARPAD
07.04.13		SCALE 1:2

